

MUST SHIP WED 29/11

Dart Aerospace Ltd.

Date: Thursday, 11/23/2006 1:09:43 PM  
 User: Kim Johnston

OK SOONER

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT LH (FOLDING)  
 Job Number : 29684  
 Estimate Number : 11652  
 P.O. Number : N/A Part Number : D2801041  
 This Issue : 11/23/2006 S.O. No. : N/A Drawing Number : D2801 REV A 1 06.11.23  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : A 1  
 Previous Run : N/A Material : N/A  
 Written By : Due Date : 11/29/2006 Qty: 2 Um: Each  
 Checked & Approved By : 06.11.23  
 Comment : Est B01.04.26 Changed D2802-041 to -1 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion

328215

PE 06.11.23 2

Check Material for any Dents or Defects

PE 06.11.23 2

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE, 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion to 86.15" long as per Dwg D2801

2-Deburr and bevel ends for welding

PE 06.11.23 2

PE 06.11.23 2

3.0 QCS INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/06/11/23 (2)

4.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2734

End Cap

328271

PE 06.11.23 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: STEP WELDMENT LH (FOLDING)

Job Number: 29684

Part Number: D2801041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D28021

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2802-1

Arm

325708

PE 06.11.23 (2)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms as per Dwg D2801

Weld end caps as per Dwg D2801

Inspect for foreign object per QSI 024

Grind end cap welds flush

PE 06.11.24  
PE 06.11.24  
PE 06.11.24  
PE 06.11.24

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

MOG/11/25 (2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MOG/11/25 (2)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M 06/11/27 (2)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06/11/28 (2x)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PE 06.11.27  
FC 06 11 28 (2)

(PTO)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/11/27	11.1	- Weld last end cap as per dwg A2801 - grind weld Flush	KE	06/11/28	2		DA 06/11/28
06/11/28	11.2	QCS QCS	DA	06/11/28	2		DA 06/11/28

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 29684

Part Number: D2801041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Wing Walk per Dwg D2801 and QSI 005 4.4

M102635 a.m 06/11/29 (28)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FC 06 11 29 (2)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

REV A1 06/11/29 (2)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/29

Job Completion



u 26.11.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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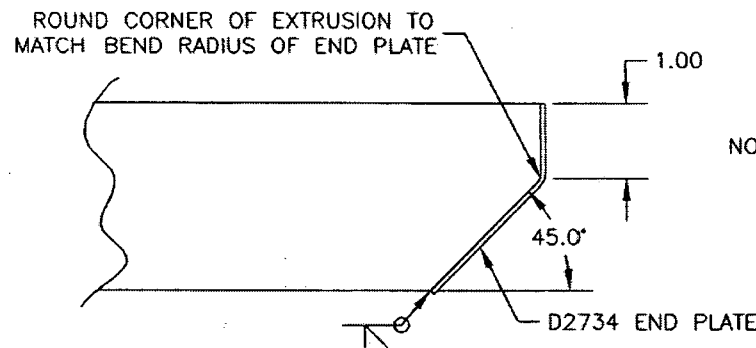
**NOTE:** Date & initial all entries

**DART**

QA  
ISSUED

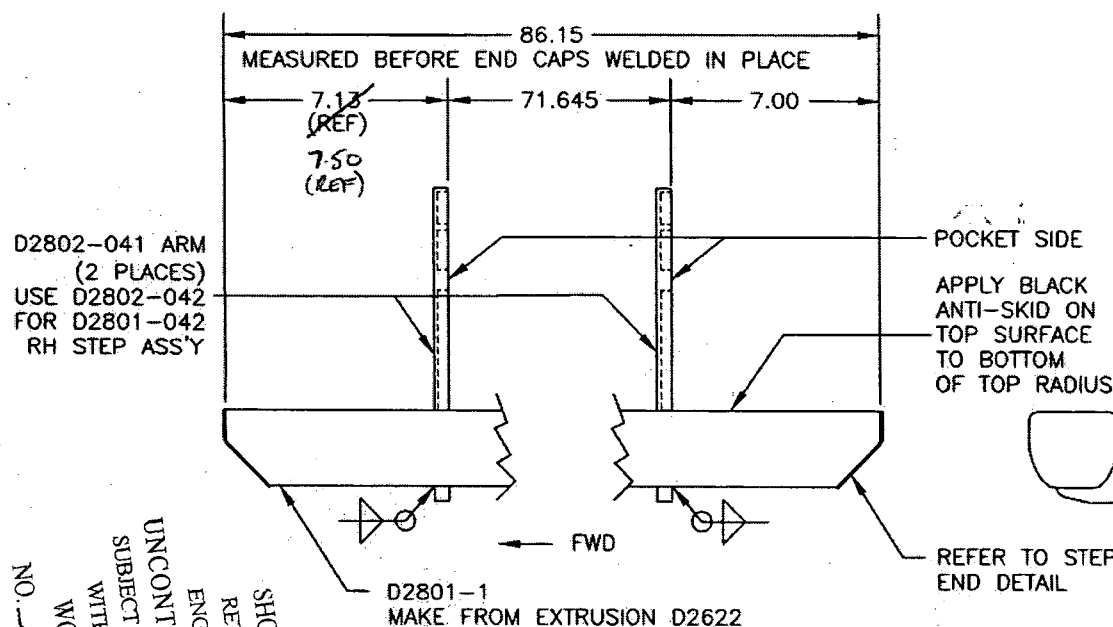
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. A
CHECKED	APPROVED	DRAWING NO. D2801	SHEET 1 OF 1
DATE 00.11.03	TITLE STEP WELDMENT	SCALE N/S	
A	00.11.03	NEW ISSUE	
A1	03.08.15	7.50 wts 7-13	

RELEASED  
00.11.13



NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

TYPICAL STEP END DETAIL  
NOT TO SCALE



D2801-041 LH STEP ASSEMBLY (SHOWN)  
D2801-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

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WORK ORDER  
NO. 29684

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